

Date: Wednesday, 01/04/2009 7:15:13 AM
User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 46760	
Estimate Number : 13130	
P.O. Number :	Part Number : D36871
This Issue : 01/04/2009 S.O. No. :	Drawing Number : D3687 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 45911	Material :
Written By :	Due Date : 22/04/2009 Qty: 8 Um: Each
Checked & Approved By : <u>C209/04/01</u>	
Comment : Est Rev:A New Issue 08-01-15 JLM Verified By:EC Est Rev:B Added Contion H-900 JLM Verified By:DD	

NOT (8)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
-----	-----------------	-----------------------



Comment: Sub-Contracting OUTSIDE SERVICES-MACH

Sub-Contracting, Ship Material to Metcor

P/O: 8148 C209/04/01

Send M74B3937 x 4750 for Heat Treating
to Condition H-900 (To become M174PHH900B3937 x 4750)
FTU IN EXCESS OF 190 KSI
FTY IN EXCESS OF 170 KSI
Certificate Required

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O for D3687-3P P.O. 8476 C209/04/01 (x8)
Machine as per Dwg D3687 Rev. B
Possible Supplier: Globus Precision
Conformity sheet required
Ship to supplier:
M174PHH900B3937X4750 B m11100 C209/04/01

3.0	M174BH900 3937X4750	17-4SS Bar 3.937x4.750 COND.H900
-----	---------------------	----------------------------------



Comment: Qty.: 0.3500 F(s)/Unit Total: 2.7997 F(s)

17-4 SS Bar 3.937 x 4.750 CONDITION H-900

Batch: m11100 C209/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 7:15:13 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46760

Part Number: D36871

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D36871P

MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
MOUNT

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH
Issue P/O: 8713
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST123

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-07

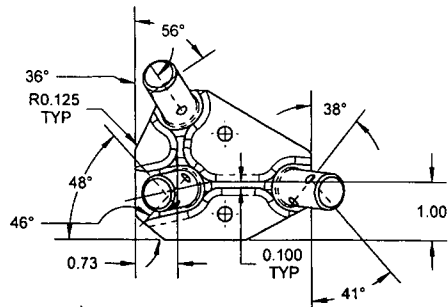
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

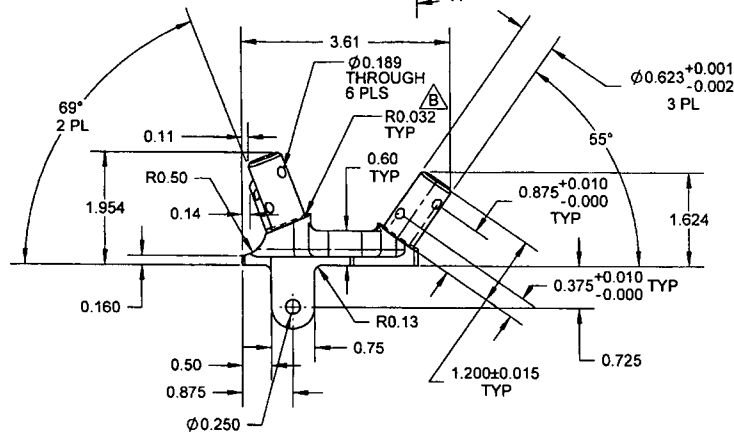
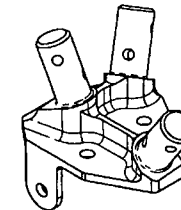
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

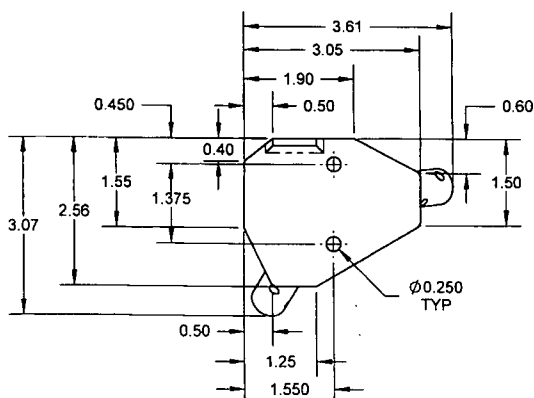


080910-1101
13/10/11 17:00



D3687-1 MOUNT

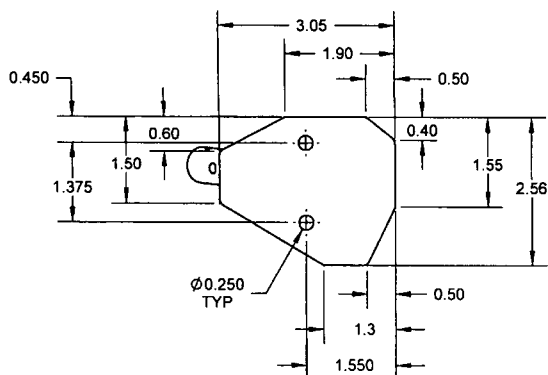
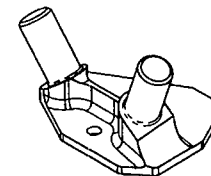
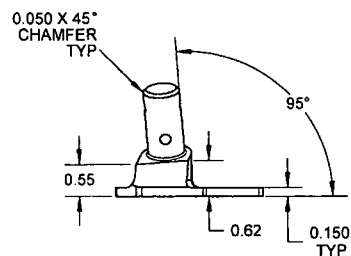
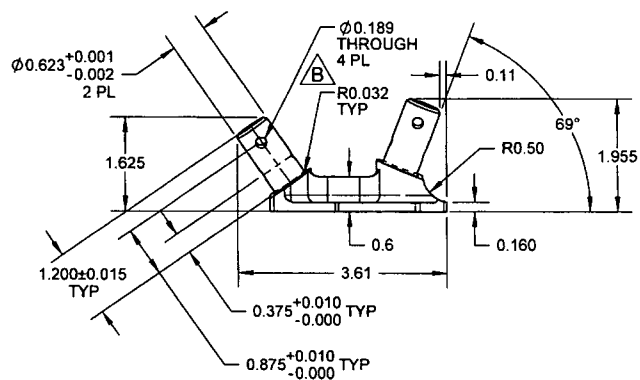
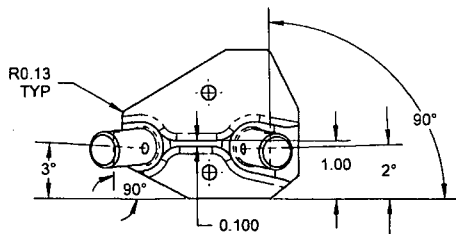
725
- 125
+ 600
150
750



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3687	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MOUNT	NTS
DATE	08.11.24	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

D3687-3 MOUNT

46760

RELEASED
08/12/15

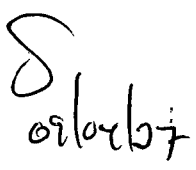
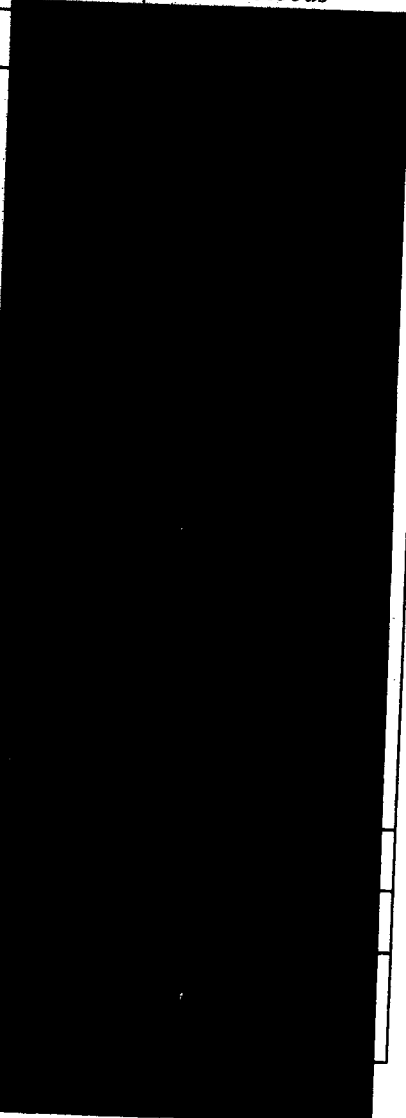

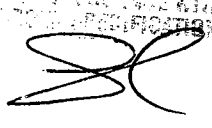
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3687	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
4/20/2009	17543

BILL TO				SHIP TO		
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7				Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB	
00008476	Net 30 Days	4/20/2009	FedEx	921	Glbous	
QTY	DESCRIPTION					
8	D36871P Rev. B Mount Business Number: 102122058    					
WHITE = Original BLUE = C of C YELLOW = Packing Slip						
Carrying Charge - 2% per Month -24% per Annum on Overdue Accounts						

METCOR INC.
 560 BOUL. ARTHUR-SAUVÉ
 ST-EUSTACHE, QC, J7R 5A8
 Tel: 450-473-1884 / Fax: 450-491-5498

Certification

Order	Load
145892	1

Customer 215
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY


ON K6A 1K7

Shipped To:
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number						
8148		17-4PH								
<p>PROCESSING SPECIFICATIONS</p> <p>AGE HARDEN CONDITION H 900 SAE AMS 2759/3 REV.E</p>										
Requirement	Specified	Tests Performed	Test Results							
HARDNESS	40 - 47 HRC	1	43 - 43 HRC							
Quantity	Weight	Part Number / Part Description								
1	320	PIECE NIL (PAS DE CONTENANT)								
Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 AGE HARDE	900 +/-10°F	1 hrs -0 +3 MIN	air			635	03-02-09	8:35	13:20	03-02-09
4.00 HARDN INS										
5.00 FINAL INSP										03-06-09

COMMENTS

APPROVED BY:		DATE: 2009-03-06
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We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.



Magna Stainless
5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006996

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

SHIP TO:
METCOR
560 ARTHUR SAUVE
SAINT EUSTACHE
SAINT-EUSTACHE, QC
J7R 5A8

Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	7996	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W007493	NET 30 DAYS		NIR:R-557065-1	02/05/09	02/11/09	02/13/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
312		LB	17-4 PH 3.937 X 4.7500 X 5" CUT 312 LB / 1 PC	L022189	253518 36279	312 312
Skids: 1			Total Weight:		312 LB	

Received by:

St. Laurent

Date:

Signature:



LIQUID PENETRANT TEST REPORT

P- 14938

CLIENT	<u>DART Aerospace</u>	DATE	<u>MAY 1-2007</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA</u>	ACUREN JOB NO.	<u>100-09-001387</u>	TIME	AM <input checked="" type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	<u>1270 ABERDEEN</u> <u>HAWKESBURY, ONT.</u> <u>K6A 1K7</u>	PO/NO NO.	<u>8713</u>	WORK LOCATION	<u>PLANT</u>		
PROJECT	<u>F.P.I.</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE	<u>2007</u>		
ITEM(S) EXAMINED	<u>MACHINED PARTS AND CROSS TUBES</u>						

JOB DESCRIPTION	PROCEDURE NO. LT-XXXX	REV./DATE	TECHNIQUE NO. LT-XXXX	REV./DATE		
PART NO.			MATERIAL	<u>STAINLESS</u>	THICKNESS	<u>—</u>
SCOPE	<u>100% EXTERNAL</u> <u>EXAMINATION</u>		<u>STEEL MACHINED PARTS</u> <u>AND ALUMINE ALUMINUM X-TUBES</u>			

TEST DETAILS						
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND	<u>MAGNAFLUX</u>		BLACK LIGHT S/N	<u>IPES</u>	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT	<u>PL 67</u>	MINIMUM DWELL TIME	<u>45</u>	MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME	<u>>10</u>	MIN.	OTHER	<u>LABING</u>
DEVELOPER	<u>SKD 52</u>	MINIMUM DWELL TIME	<u>10</u>	MIN.	LIGHT METER S/N	<u>—</u>
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		CAL DUE DATE	<u>FEB 2010</u>

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS-	<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL																											
<table><thead><tr><th>COMPLETION</th><th>ACCEPT</th><th>REJECT</th></tr></thead><tbody><tr><td><u>QCB # 46760 - 8 PCS</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 46761 - 2 PCS</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47284 - 1 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47283 - 1 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47155 - 1 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47156 - 1 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47371 - 1 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 46699 - 12 PC</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr></tbody></table>		COMPLETION	ACCEPT	REJECT	<u>QCB # 46760 - 8 PCS</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 46761 - 2 PCS</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47284 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47283 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47155 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47156 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47371 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 46699 - 12 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
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<u># 46699 - 12 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>																										
<u>ALL ITEMS EXAMINED WERE FOUND ACCEPTABLE</u>																												

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE	<u>Jason Hancock</u>	PRINT	SIGNATURE	DTR #	<u>E-27911</u>
TECHNICIAN (SIGNATURE):	<u>Mike Johnson</u>	1 ST TECHNICIAN	2 ND TECHNICIAN	REPORT REVIEWED BY:	
NAME (PRINT):	<u>Mike Johnson</u>	CGSB LEVEL	<u>II</u>	SNT LEVEL	
		CGSB REG. NO.	<u>6000</u>		